



Dart Aerospace Ltd.
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D5624-1
Job Sheet 196126



Part No: D5624-1
Part Name: Ball Stud

Job Qty: 40 pcs
86 pcs. Dr

Part Weight: 0 lbs
Job Created: 6/7/19
Due Date: 6/28/19
Type: Stock
Note: D5624 REV.A IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS
Ship Via:

Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description: SIOP

Priority: Medium

ENGINE
SOLD
SOLD

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	40 pcs	6/28/19	6/28/19	1.00	5.19	Doosan - 1		<i>22 19-6-17</i>
110	QC 2	40 pcs	6/28/19	6/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		<i>11</i>
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

NCR: 19-7252

120 QC 8	40 pcs	6/28/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	MK 19/06/18
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Packaging 3-1 - Stock - B4B 40 pcs		6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 173
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	2-25 JUN 19 2019
Part Op 100 - 1-TURN AS PER FOLIO F_____ & DWG D5624 , Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location:_____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304R0.625	304 SS Round bar 0.625	4.1600 ft (.104 ea)	100-Doosan - 1	S071719	
		- 093			
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M304R0.625	4	8	0	
Part Specifications					
Specifications could not be found.					

Plex 6/7/19 8:38 AM Dart.lajeunesse.marie

Entered:

Date:

NCR No. 19-7252

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



md
July 5, 2019

Job: 196126
Part No. D5624-1

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☒

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☒

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date:

Sequence #:

QTY Affected:

MRB (QS1042)

Description Work Order Deviation

Disposition

304 used instead of 303

Acceptable to use 304
mat'l.

Completed by

INSR
12 4/14/19

Lead hand / Supervisor
Jean Luc Menard

Signature: JLM

QC / QA Coordinator

DAS

55

9-89

July 5, 2019

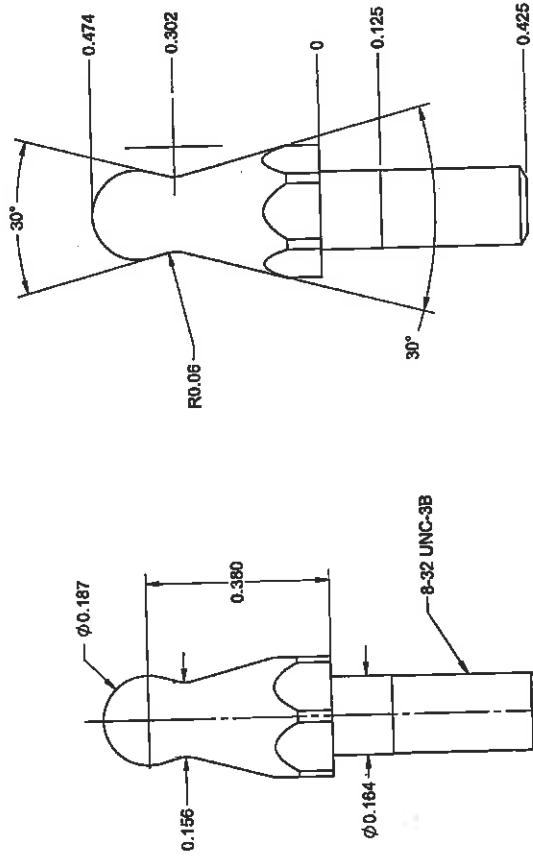
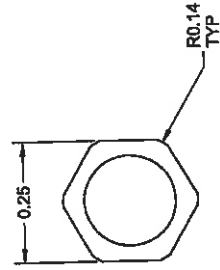
Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☒
Human Factors ☒

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☒
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐



NOTES:
1) MATERIAL: AISI 303 HEX BAR OR AISI 303 ROUND BAR
PER ASTM A382
REF PART SPEC M303H OR M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 & 7
7) WEIGHT: 0.01 lbs

ADVERT

2018 APR 09 10
ENC 18-706

ECN 18-706

ECN 18-706

A		NEW ISSUE		VS		BY		18.02.28	
REV.		DESCRIPTION							
DESIGN		VS		DART AEROSPACE LTD					
DRAWN		VS		HAWKESBURY, ONTARIO, CANADA					
CHECKED		WK		DRAWING NO.					
MFG. APPR.		JFS		REV. A					
APPROVED		DSW		SHEET 1 OF 1					
DIE APPR.		DSW		TITLE		SCALE		NTS	
				BALL STUD					
DATE		18.02.28		CONTINUED ON 31 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC THROUGHOUT THE WORLD. NOT TO BE USED FOR ANY PURPOSE OR TO DISCLOSE OR REPRODUCE INFORMATION THEREOF.					

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